

Date: Thursday, 15/01/2009 11:13:49 AM
 User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 44795-2
 Estimate Number : 10721
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D34637
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3463 REV.B
 Previous Run : 41766 Project Number : N/A
 Material :
 Written By : Due Date : 27/02/2009 Qty: 9 Um: EACH
 Checked & Approved By : JLD 09.01.15
 Comment : EST REV> A 05.11.18 new issue EC
 Est Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W120 304 ss round tube .750 x .120w



Comment: Qty.: 1.0000 f(s)/Unit Total : 12.0000 f(s)
 AISI 304 SS seamless tubing 0.750 OD X 0.120 wall
 (M304TR0750W120)
 Batch: M109162

M-L 09/01/29

(12x)

(7x)

M110672

(5x)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to 13.875"

M-L 09/01/29

(12x)

2-Deburr

M-L 09/01/30

(12x)

3-Bend end as per dwg D3463

FF 09/01/30

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/06



4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Mill as per dwg D3463

2-Drill hole & ream to 0.4385" as per dwg D3463

S 09/02/05

3-Deburr

(11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-7 PAR #: NA Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 09/02/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/02/11

NCR: <u>44795-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/06</u>	<u>4.0</u>	<u>One part the hole of .437</u> <u>was off center.</u> <u>R.C. We tried too center the</u> <u>Hole with the tube and the</u> <u>tube was cracked.</u> <u>Process</u>	<u>[Signature]</u>	<u>Scrap is no replace.</u> <u>Centering measurement</u> <u>will be taken on the Flat</u> <u>Section. Product done manually</u>	<u>SB</u> <u>09/04/06</u>	<u>[Signature]</u> <u>09-02-06</u>	<u>[Signature]</u> <u>09-02-06</u>	<u>[Signature]</u> <u>09-02-06</u>

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:13:49 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 44795

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SS 09/01/09

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JF. 09/02/09

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Grind .450" rad

F.T.

(8X)

m-h

09/02/09

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/09 (CS)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Carl

SS 09/02/09 (CS)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09

Job Completion



mf 09-02-09

Dart Aerospace Ltd

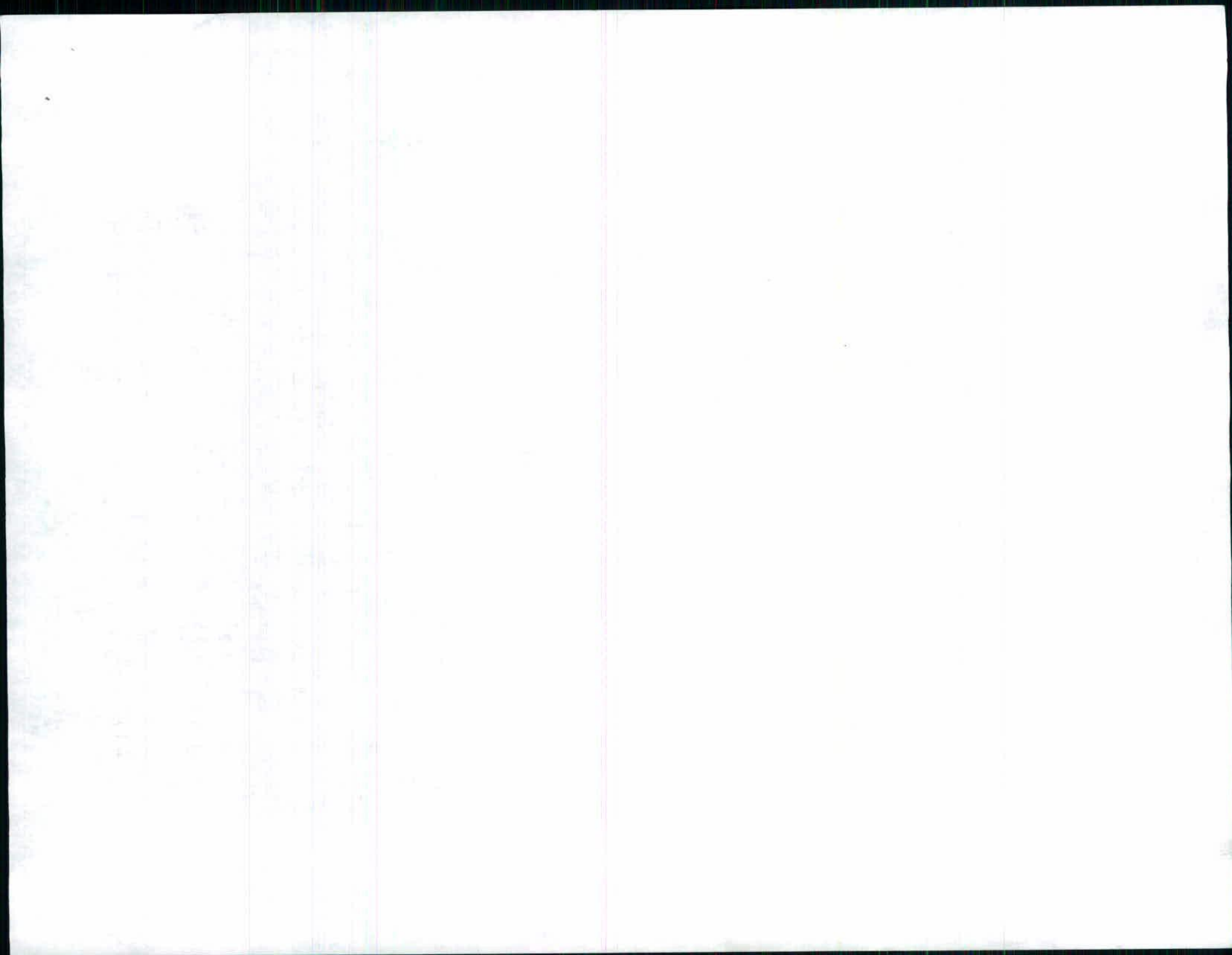
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

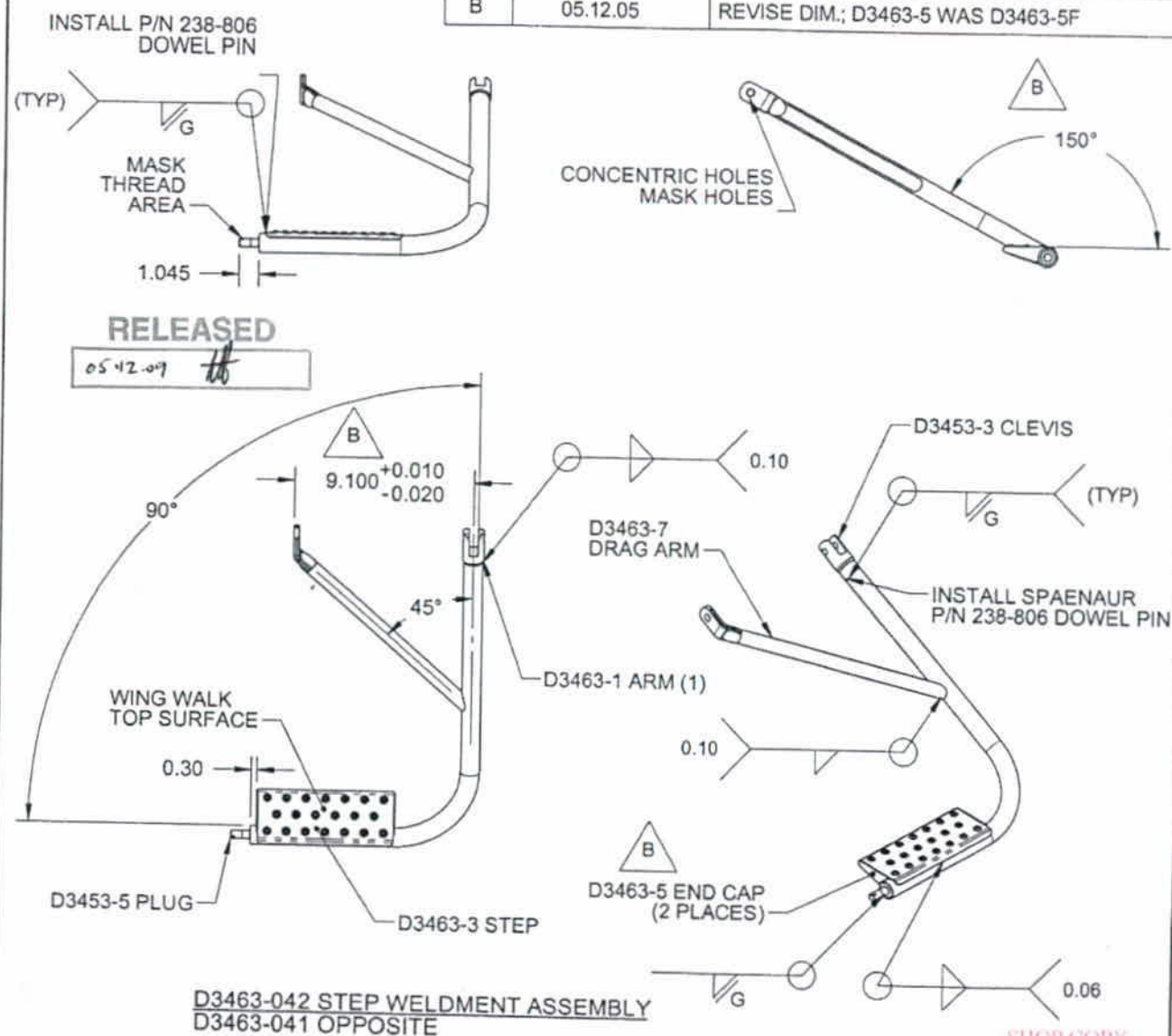
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

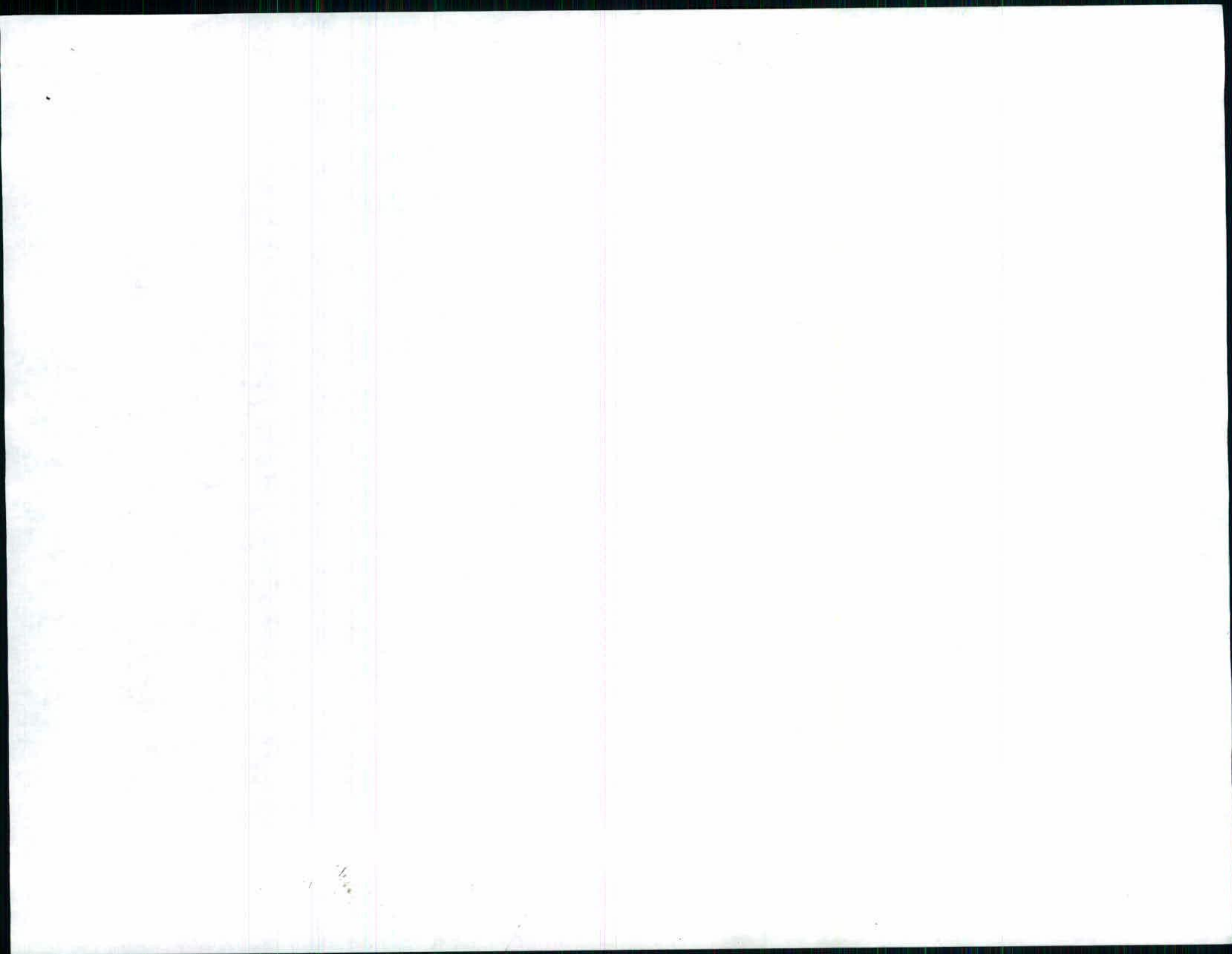
**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. 44795

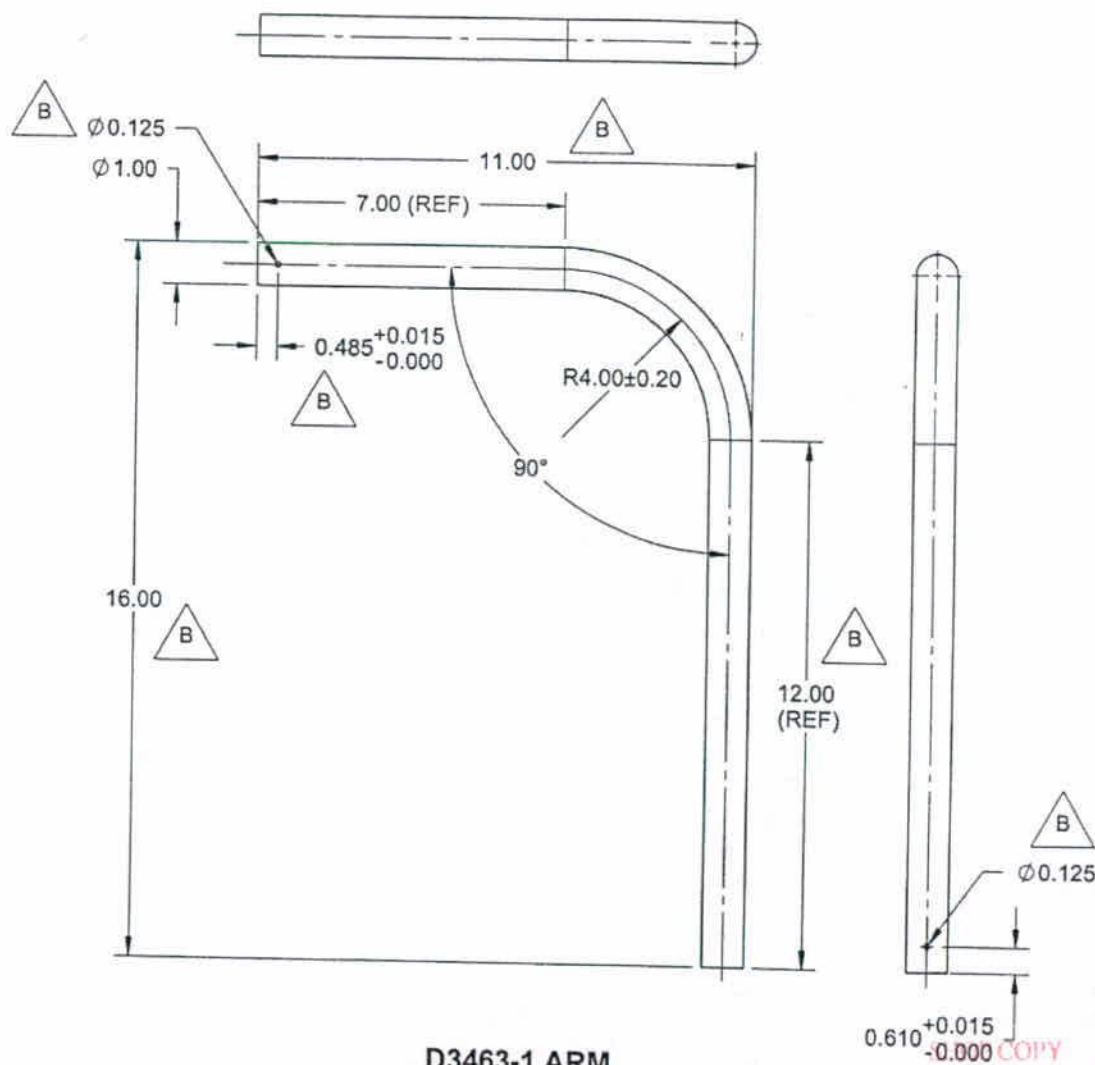
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

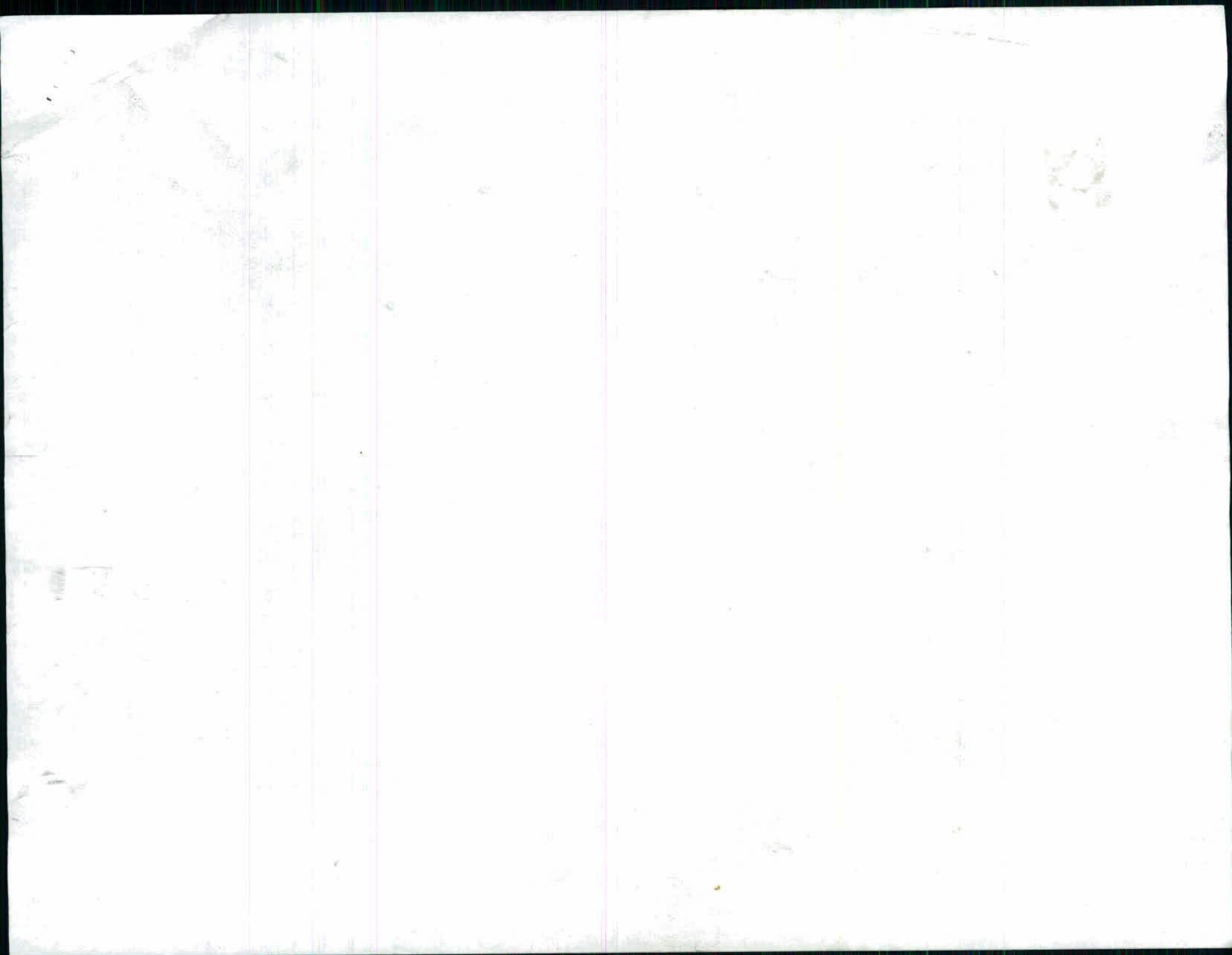
RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

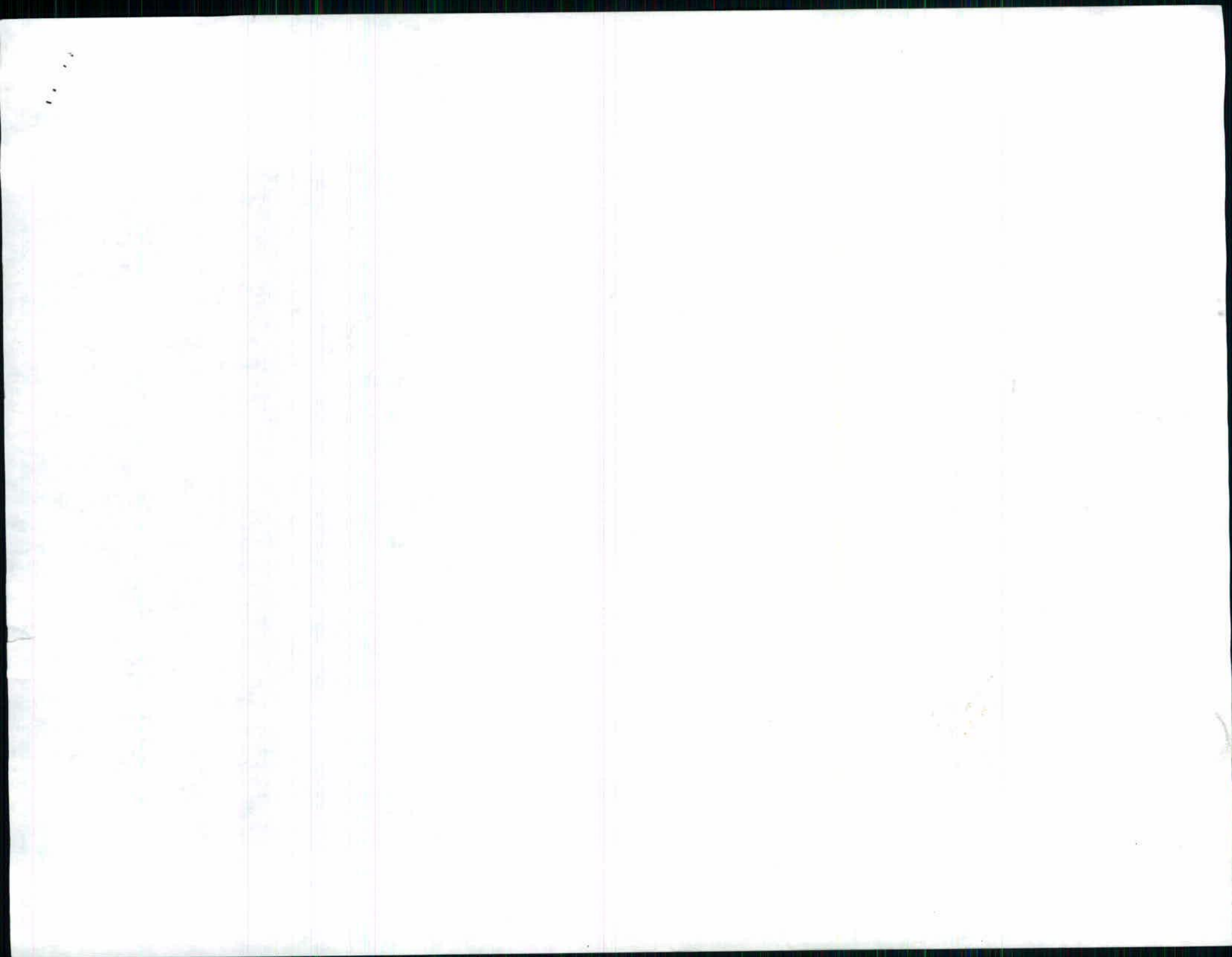
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF, DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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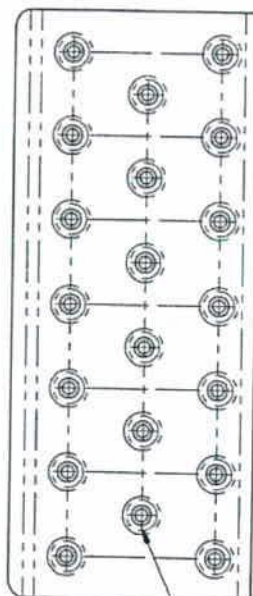
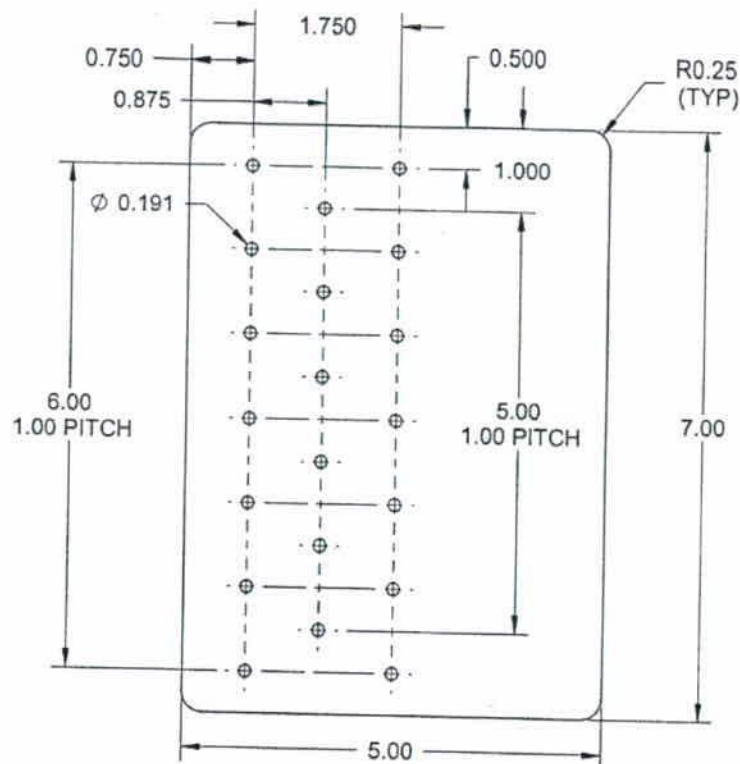
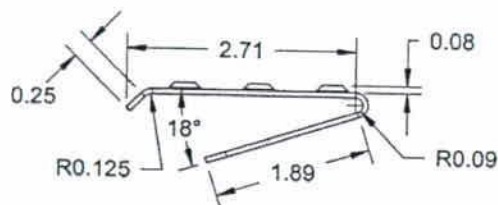
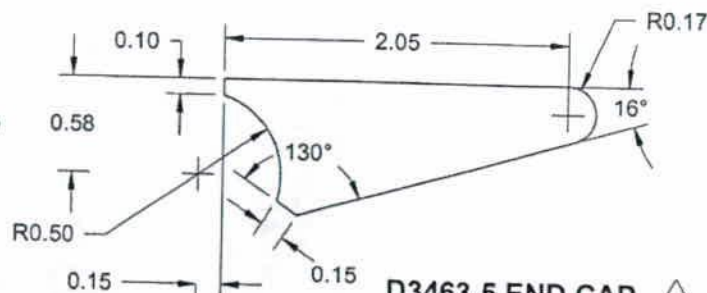


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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.05 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**

SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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